

Work Order ID 66052

Thursday, February 03, 2011 11:32:29 AM



Page 1

Item ID: D4317-7

Accept



Setup Start



Revision ID: PRELIM

Item Name: GPS Plate

Stop



Start Date: 2/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 1.00

Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: mf

Date: 11-02-03 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4317	PA1

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

4130 . 063

1-Cut as per Dwg

Dwg Rev: QAF

Prog Rev: PA1

2-Deburr if necessary

FB 11-2-4

(1)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

FB 11-2-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66052

Thursday, February 03, 2011 11:32:29 AM



Page 2

Item ID: D4317-7

Accept



Setup Start



Revision ID: PRELIM

Item Name: GPS Plate

Stop



Start Date: 2/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspect to spec



QC

Memo

0.00

Qty only
Sulaboz (K)

Quality Control

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Pl 11-02-15

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

66051

Quality Control

POSITIVE RECALL

EFFECTIVE 11-02-03 AUTH MF

RELEASED DATE 11-02-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 03, 2011 11:32:26 AM

Page 1

Work Order ID: 66052



Parent Item: D4317-7



Parent Item Name: GPS Plate



Start Date: 2/4/2011

Required Date: 2/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.02 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NS.063 		Purchased	No			100	sf	10.0000	0.3906	0.411158			
4130 Sheet .063													

11-2-4

Location

Loc Qty

Loc Code

MAT19

10

103433

10

103433



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 6605
Description: GPS PLATE		Part Number: D4317-7
Inspection Dwg. D4317-7 , Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

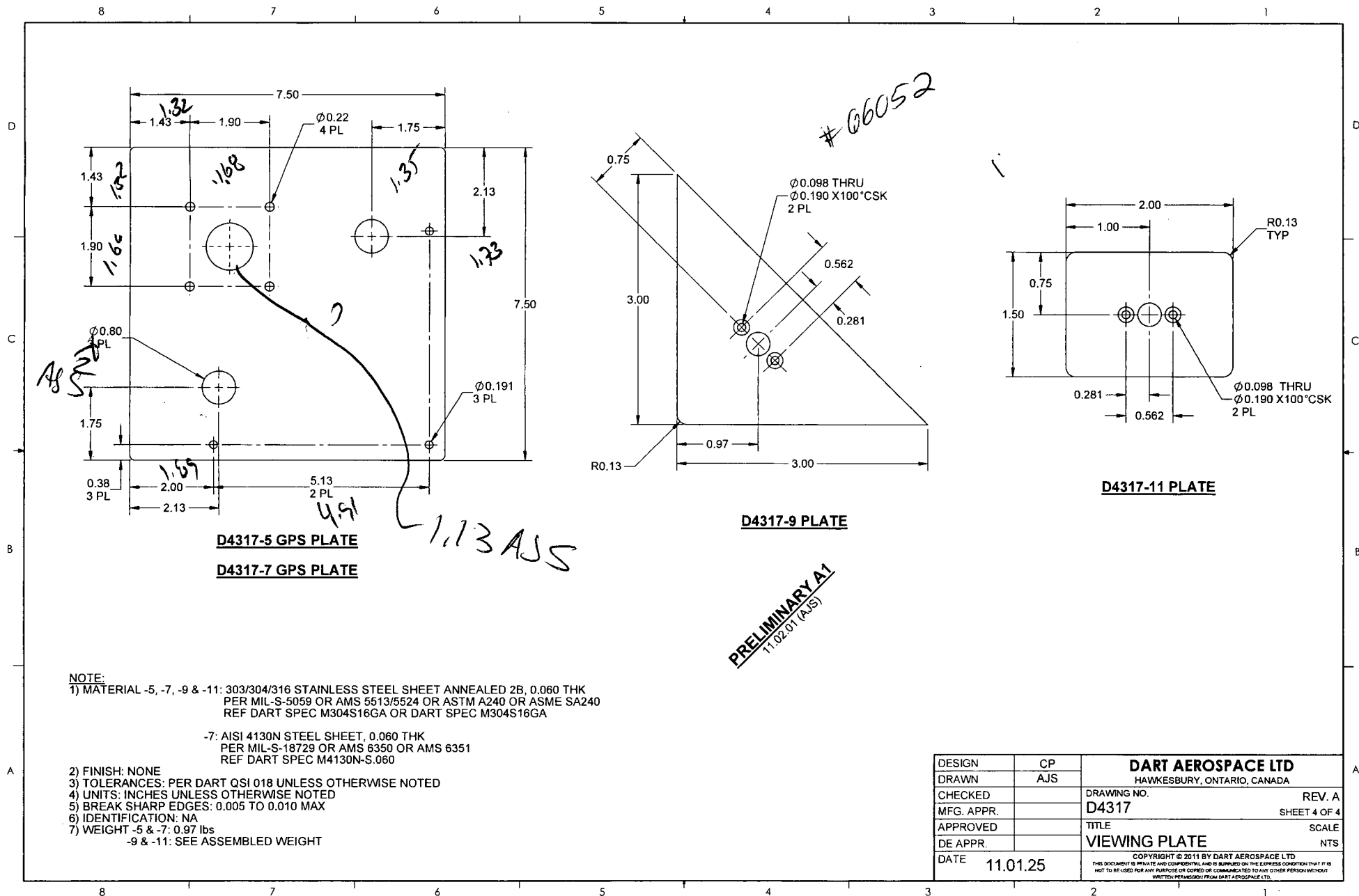
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .22	+ .005 - .001	.220	✓		V HB02	
Ø .191	+ .005 - .001	.191	✓		V	
Ø .80	+ .010 - .001	.800	✓		V	
1.43	± .020	1.424	✓			
1.90	± .030	1.896	✓			
1.75	± .030	1.752	✓			
7.50	± .030	7.510	✓			
2.13	± .030	2.127	✓			
7.50	± .030	7.503	✓			
5.13	± .030	5.127	✓			
2.00	± .030	2.002	✓			
2.13	± .030	2.128	✓			
.38	± .030	.375	✓			
1.75	± .030	1.754	✓			
1.90	± .030	1.900	✓			
1.43	± .030	1.425	✓			
.060	± .010	.063	✓			

Measured by: JB
Date: 11-2-4

Audited by: S
Date: 11/02/07

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries